













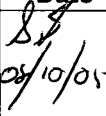
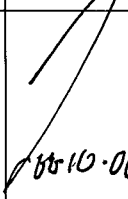


Date: Monday, 22/09/2008 1:05:26 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 42181	
Estimate Number : 10980	
P.O. Number :	Part Number : D2808
This Issue : 22/09/2008 S.O. No. :	Drawing Number : D2808 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 41708	Material :
Written By :	Due Date : 29/09/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JULIO 08.9.22</u>	
Comment : Est Rev:D 02.03.07 Now turned in house NG Est Rev:E 07-12-18 RevB as per dwg ECN1048 DD verified by:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6R0625 6061-T6 Round Bar .625"
	  (42)
Comment: Qty.: 0.0557 f(s)/Unit Total : 2.2260 f(s) 6061-T6 Round Bar .625" (M6061T6R0625) Batch: <u>M108548</u> <u>mnp 08/09/27</u>	
2.0	HARDINGE HARDINGE CNC LATHE SMALL
	  (42)
Comment: HARDINGE CNC LATHE SMALL <u>mnp 08/09/29</u> 1-Turn as per Folio FA256 (Measure D3387 Bracket .507" Dia for Proper press-fit) 2-Deburr	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	  (42)
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mnp 08/09/29</u>	
4.0	QC8 SECOND CHECK
	  (42)
Comment: SECOND CHECK <u>M.A 08/10/02</u>	
5.0	HAND FINISHING1 HAND FINISHING RESOURCE #1
	  (42X)
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>M-f 08/10/06</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2808 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: D Date: 08/10/09  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 42181		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/09		at the second check I found the diameter of .313 $\pm$ .005 was .320 so it was .002" over tolerance. R.C. material build up.	 08/10/09	Parts will be acceptable upon ASS'y.	 08/10/09	 08/10/06	 08/10/09	 08/10/06

NOTE: Date & initial all entries

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User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 42181

Part Number: D2808

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-06

XOR

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 48

8/10/06

50

42x

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



4 08.10.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

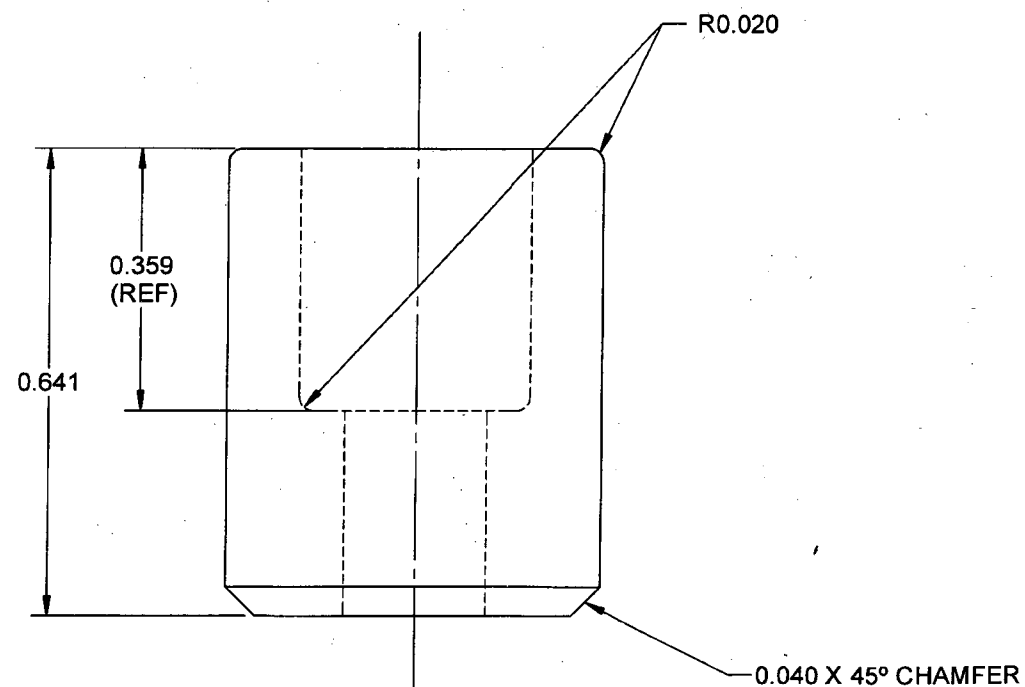
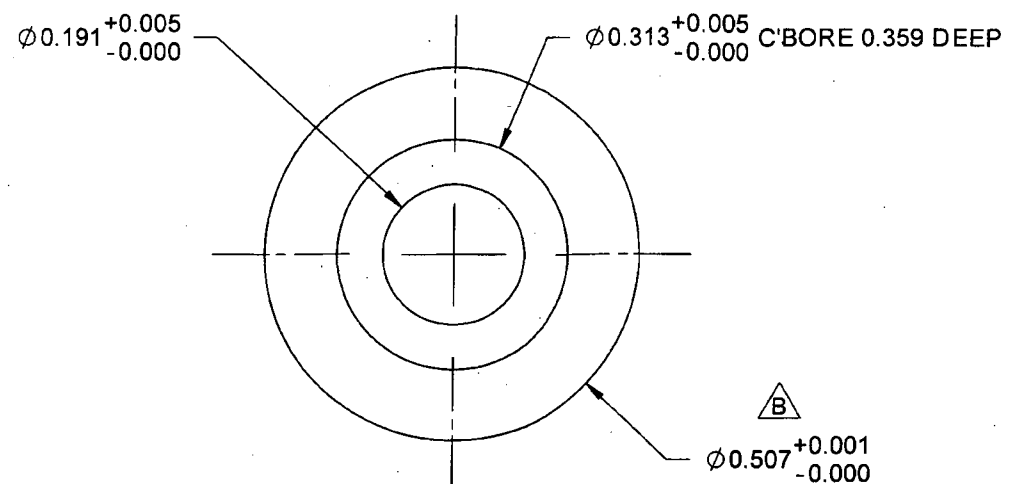
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# **D2808 SPACER**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40281

B	REMOVE POWDER COAT; Ø0.507 WAS Ø0.500	DC	07.10.12
A	NEW ISSUE	DS	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2808	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER	4:1
DATE	07.10.12	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	